

Work Order ID 97006

February-14-13 1:02:57 PM

97006

Page 1

Item ID: D3912-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Eyebolt Receiver Assembly

Stop *NS2*

Start Date: 2/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/25/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 13-02-15 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D3912 B

100 Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

4x

ES 13/03/18

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

4x

ES 13/03/18

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

27
9.6
133 18

4

Work Order ID 97006

97006

Page 2

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Item ID: D3912-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Eyebolt Receiver Assembly

Start Date: 2/13/13 Start Qty: 4.00

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST072</u>	0.00							
170									
Packaging	Memo	0.00				4X			SD
Packaging									13-3-18
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							13/3/20 JA
Quality Control									

RB-03-19

Picklist Print

February-14-13 10:44:47 AM

Page 1

Work Order ID: 97006

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 2/13/13

Required Date: 2/25/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B 10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R Washer		Purchased	No				Each	75.0000		4	4	2/13/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST292		75				4			
				116893		75							
D3912-1 Eyebolt		Manufactured	No			100	Each	32.0000	1	4	4	2/13/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST144		32							
				77073		2				4			
				92638		13							
				93713		17							
D3912-3 Eyebolt Block		Manufactured	No			100	Each	45.0000	2	8	8	2/13/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST144		45							
				88265		7							
				90533		8							
				91865		2							
				92663		12							
				93746		16				8			

Picklist Print

February-14-13 10:44:48 AM

Page 2

Work Order ID: 97006

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 2/13/13

Required Date: 2/25/13

Start Qty: 4.00

Required Qty: 4.00

D3912-5
Eyebolt Plate

Manufactured No

100 Each 36.0000

2

8

2/13/03/18

Location

Loc Qty

Loc Code

ST144

24

83367

1

88406

23

ST145

12

93796

12

8

D3801-1

Hand Retractable Spring Plunger

Manufactured No

Each 20.0000

4

2/13/03/18

Location

Loc Qty

Loc Code

GA

2

82615

2

ST066

18

75178

11

93789

7

97963(4x)

MS20615-4M20
RIVET

Purchased No

100 Each 223.0000

8

32

2/13/03/18

Location

Loc Qty

Loc Code

GA

223

119546

26

120644

7

121339

9

121463

32

122807

149

32

MS21209-F615
Heli-Coil

Purchased No

Each 12.0000

4

2/13/03/18

Location

Loc Qty

Loc Code

GA

12

121561

12

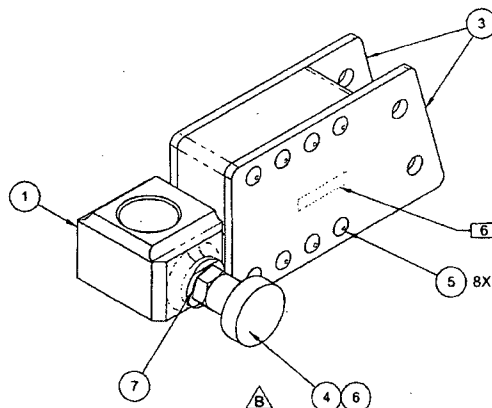
4

February-14-13 10:44:48 AM

Shop Packet Print

Page 2

ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



D3912-041 EYEBOLT RECEIVER ASSY

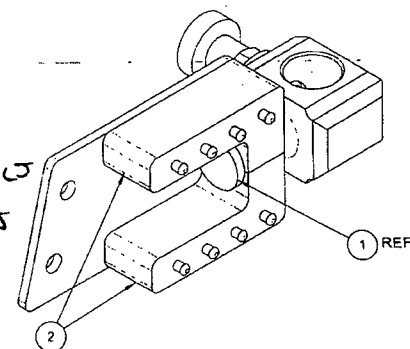
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

SHEN
REF
ENGR

UNCONTROLLED
SUBJECT TO

WHICH
WORK
NO. 97-006 MC
13-02-15

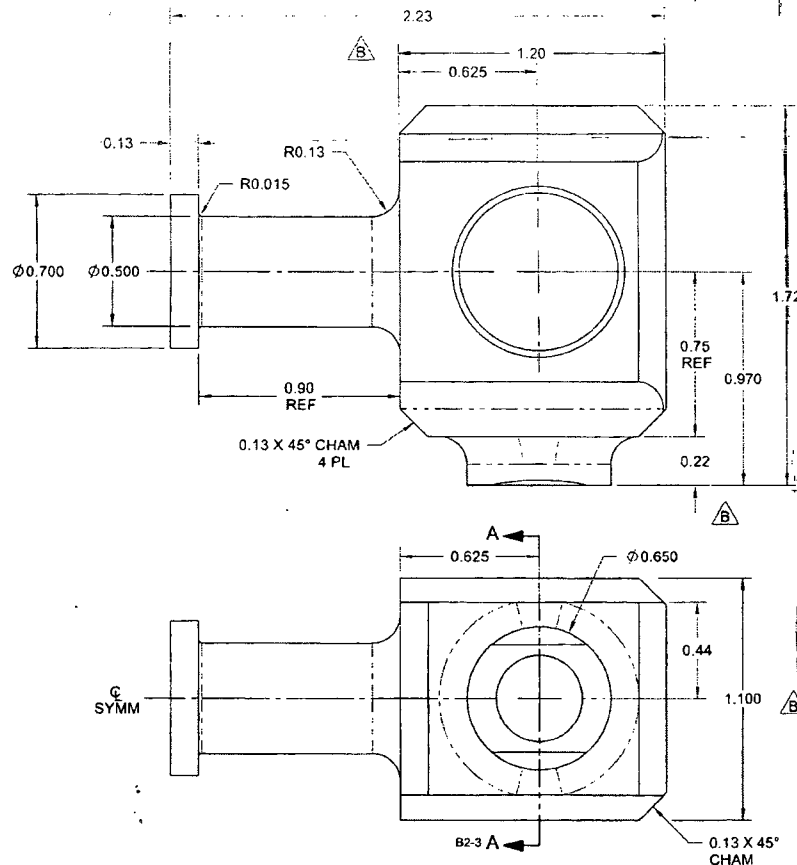


SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1/5	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	1/5		
CHECKED	1/5	DRAWING NO.	REV. B
MFG. APPR.	1/5	D3912	SHEET 1 OF 3
APPROVED	1/5	TITLE	SCALE
DE APPR.	1/5	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

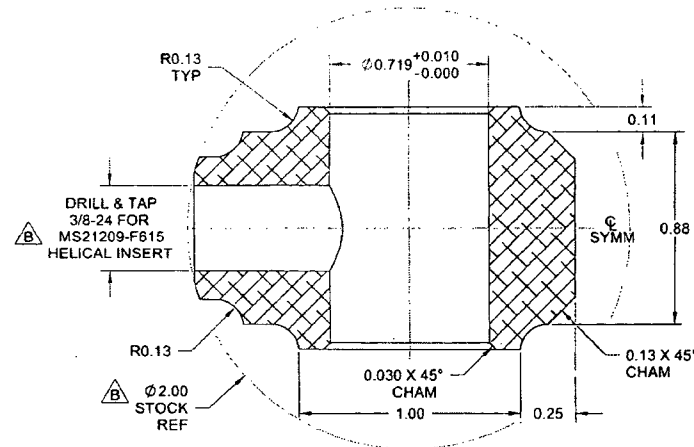
97006



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs

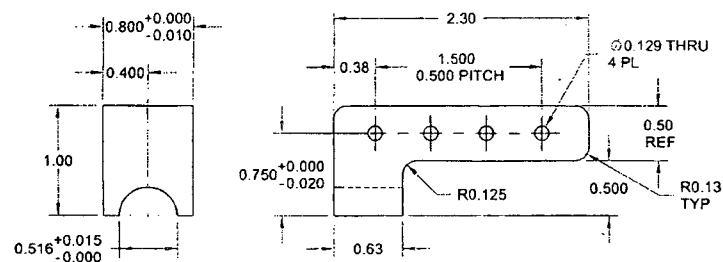


SECTION A-A B6-3

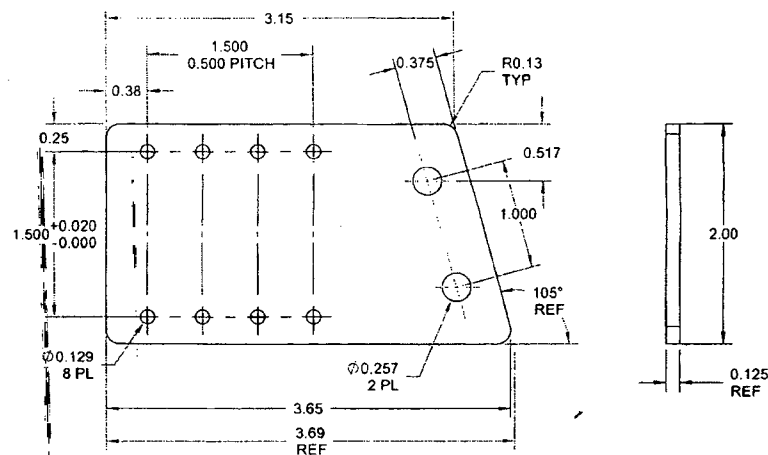
RELEASED
2010-07-16
JMP

DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J	DRAWING NO.	REV. B
CHECKED	J	D3912	SHEET 2 OF 3
MFG. APPR.	J	TITLE	SCALE
APPROVED	J	EYEBOLT RECEIVER ASSY	NTS
DE APPR.	J	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. AND IS APPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.06.28		

97006



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
md

DESIGN	<i>HS</i>	DART AEROSPACE LTD	
DRAWN	<i>HS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>HS</i>	DRAWING NO. D3912	REV. B
MFG. APPR.	<i>HS</i>	TITLE	SHEET 3 OF 3
APPROVED	<i>HS</i>	EYEBOLT RECEIVER ASSY	SCALE
DE APPR.	<i>HS</i>		NTS
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